

Date: Friday, 25/07/2008 4:20:50 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 40762
 Estimate Number : 13508
 P.O. Number : Part Number : D21953
 This Issue : 25/07/2008 S.O. No. : Drawing Number : D2195 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : SMALL /MED FAB Drawing Revision : C
 Previous Run : Material :
 Written By : Due Date : 20/08/2008 Qty: 2 Um: Each
 Checked & Approved By : JUL 08.7.25
 Comment : Est Rev:A 08-07-24 new issue ec verified by:dd

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .500 x 5.00



Comment: Qty.: 0.3686 f(s)/Unit Total: 0.7371 f(s)
 6061t6 bar 5.00" x .50" thick
 batch: 105747 HB 8-8-21

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2195
 Dwg Rev: C
 Prog Rev: C

HB 8-8-21

2-Deburr if necessary

HB 8-8-21

D ② Hm 08/08/21

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-8-21

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/08/21 (x2)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

08/08/22

(x2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 25/07/2008 4:20:51 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40762

Part Number: D21953

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.08.22

(V2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: 18

8/8/25

(2x)

SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/25/2

Job Completion



U 08.08.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

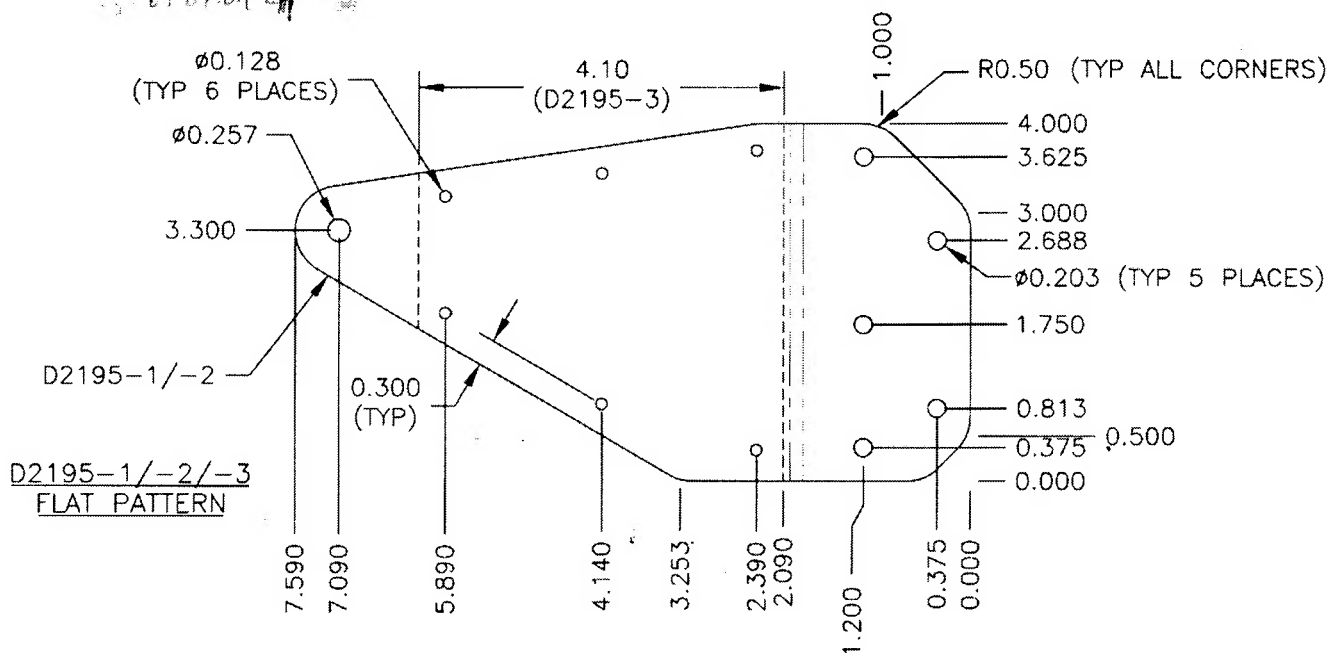
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2195	REV. C SHEET 1 OF 1
DATE 03.05.28		TITLE BRACKET	SCALE 1:2
B	93.09.23	RE-DESIGN	
C	03.05.28	REDRAW; D2195-3 NOW 0.5" THICK	



D2195-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2195-3

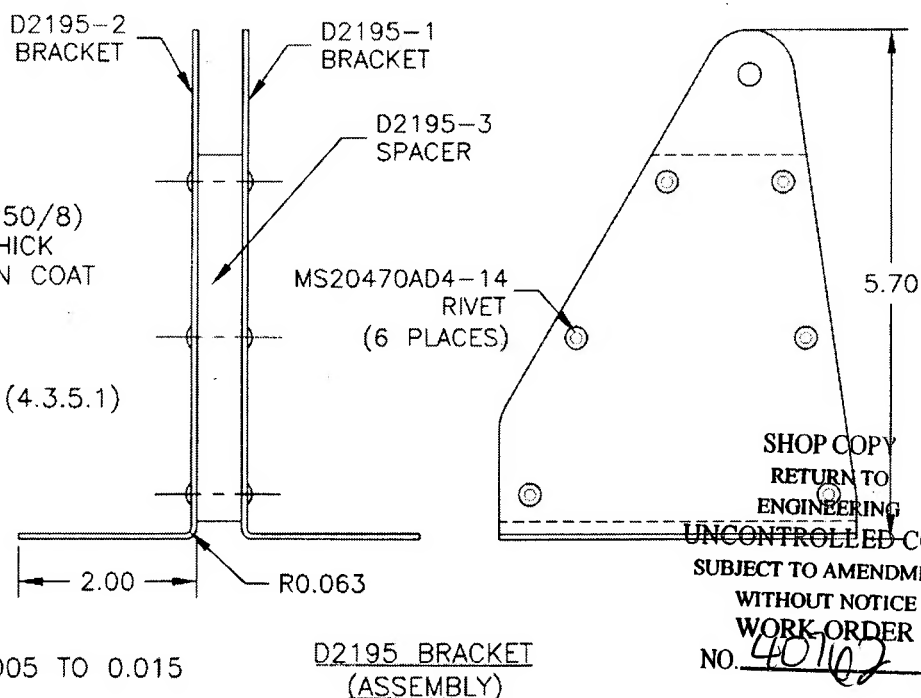
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK OR 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2195 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



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